

Item ID: 606.7814

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Plunger Cap

Start Date: 3/1/2016 **Start Qty:** 5.00

5

Cust Item ID:

Required Date: 3/1/2016 **Req'd Qty:** 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐								

Work Order ID 141904

141904

Page 2

Friday, February 19, 2016 10:37:25 AM

Item ID: 606.7814 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plunger Cap
Start Date: 3/1/2016 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 3/1/2016 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				5	0.00		
130		0.00							
Packaging	Memo								
Packaging	LOCATION: MAT060								MAR 03 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140		0.00							
QC	Memo								MAR 03 2016
Quality Control									

MAR 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Page 1

Friday, February 19, 2016 10:37:24 AM

Work Order ID: 141904

141904

Parent Item: 606.7814

606 7814

Parent Item Name: Plunger Cap

Start Date: 3/1/2016

Required Date: 3/1/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 15.05.04 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750		Purchased		No			f	26.0700		0.223684			

M304RO 750

304 SS Roundbar .750

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT029	26.07	
M128005	0.247	
M128496	2.373	
M133587	12	
M134158	11.45	

0531 [#]

DAS
45 2016-03-02
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

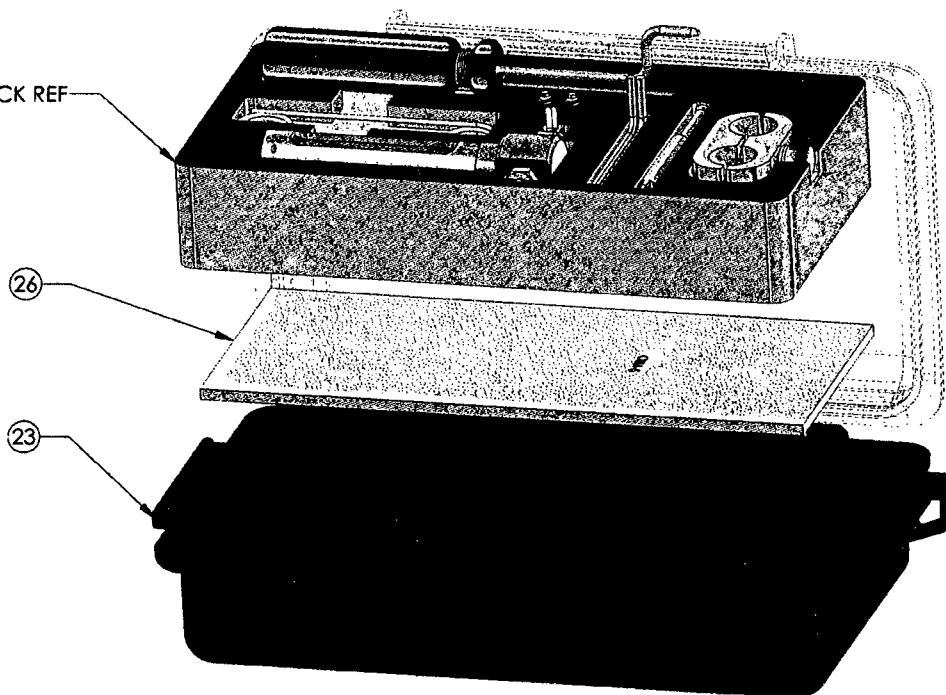
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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NOTES:

1. IDENTIFY PER MPP-120.
- 2 MATERIAL: AISI TYPE 304 STAINLESS STEEL.
- 3 APPLY ANTI-SIEZE AS REQUIRED.
- 4 MATERIAL: MCMASTER CARR P/N 8860K26.
BEND 6IN WIRE INTO SPECIFIED SHAPE.
- 5 MAKE FROM P/N 601.3825 SCREW DRIVER. BEND BLADE SHAFT TO SHAPE
AND DIMENSIONS SHOWN.
- 6 MATERIAL: 600.0062 FOAM.
- 7 APPLY LABELS P/N 601.3830 & 601.3831 AS SHOWN.
- 8 FINISH IAW MPF-172:
ELECTROPOLISH PER SECTION 7.0
PASSIVATE PER SECTION 6.0

FOAM PACK REF

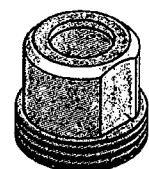
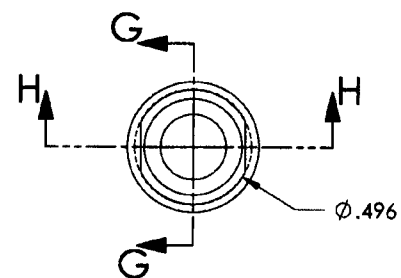


606.7803

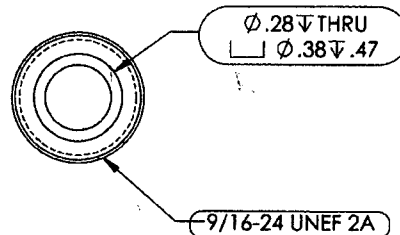
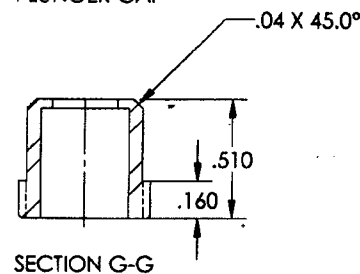
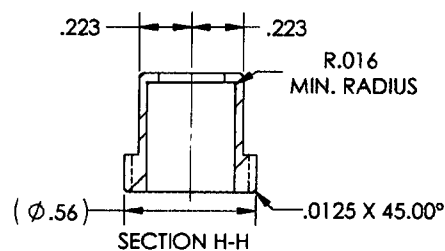
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: PPS		PPS
2	INITIAL RELEASE	11-26-15	P. BRAVO

1	-	26	OIM-5	OPERATION INSTRUCTIONS		
1	-	25	601.3831	DART LOGO LABEL		
1	-	24	601.3830	LABEL		
1	-	23	601.3829	PELICAN 1060 MICRO SERIES CASE		
1	-	22	606.7822	FOAM	△	
1	-	21	606.7821	TEST PULL ROD	△△△	
1	-	20	606.7820	RESET TOOL	△	
1	-	19	601.3824	HEX L-KEY 7/64"	7122A17	
1	-	18	601.3823	HEX L-KEY 3/32"	7122A16	
1	-	17	601.3822	SEALING HEX NUT	91339A120	
3	-	16	601.3821	SET SCREW	90291A827	
1	-	15	601.2591	SCREW	AN500-AD4-2	
1	-	14	601.3796	KEY RING		
2	-	13	601.2937	O-RING	AS568A-008	
1	-	12	606.7814	PLUNGER CAP	△△△	
1	-	11	601.3775	SPRING		
1	-	10	606.7815	PLUNGER	△△△	
1	-	9	645.6910	PULL ROD		
1	-	8	606.7810	PULL ROD HOUSING	△△△	
1	-	7	645.7710	SHROUD		
1	-	6	601.1084	O-RING	AS568A-006	
1	-	5	601.3819	WASHER	92141AD09	
1	-	4	601.3867	THUMB SCREW	99407A139	
1	-	3	606.7819	CLAMP LOWER HALF	△△△	
1	-	2	606.7823	CLAMP UPPER HALF	△△△	
2	-	1	606.7818	RETAINER WIRE	8860K26	
X	-		606.7803	PULL CABLE TEST KIT		
X	-	1	606.7802	CLAMP ASSY		
X	-		606.7801	PULL CABLE TEST FIXTURE		
7803,7802,7801	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	
QTY			PARTS LIST			
NEXT ASSY (S)			DART 3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760) 724-5300			
NONE			APICAL INDUSTRIES INC. DART AEROSPACE			
			PULL CABLE TEST FIXTURE-DART VALVE			
			REV. 07/26/15			
			SHEET 1 OF 11			

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606.7814
PLUNGER CAP



ORIGINAL DATE 11/24/15		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 724-5500 APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWN BY J. SICKLER	CHECKED P. BRAVO		
DRAWING APPROVAL P. BRAVO 11/24/15		PULL CABLE TEST FIXTURE-DART VALVE	
CONTRACT NO.		SHEET B	OF 11
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 ANGLES ±.5°		DWG. NO. 606.7800	REV. N/C
		SCALE NONE	SHEET 4 OF 11

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Apical Industries, Inc.
dba Dart Aerospace
3030 Enterprise Ct., Suite A
Vista, CA 92081-8347
T 760 724 5300
F 760 509 1562

Change Order

Order #: P1559
Prepared By: Sarah Arango
Date Printed: 2/17/2016
Time: 11:02:02 AM
of Items: 6
Page: 1

Purchased From:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA



Ship To:
Apical Industries, Inc.
dba DART Aerospace
3030 Enterprise Court
Suite A
Vista, CA 92081
United States

REPLY WITH
CONFIRMATION
OF ORDER

PO Date: 2/16/2016 Cust Ref#: E-MAIL REQ JACO Vendor #: DAL1 Customer:
Need Date: 0 Terms: NET 30 DAY Phone #: 1-613-632-3336 Fax #: 1-613-632-4443
Remarks: E-MAIL REQ JACOB. B CABLE KITS Resale: YES Resale #:

Insure?: Please Insure Ship Via: UPS GROUND

Account:

FOB: ON

Change Order -- Do Not Duplicate

Item	Part Number/Description	CD	Qty	Req Date	Unit Price	Line Amt
1	606.7819 CLAMP HALF REV NC	NE	5.00	3/2/2016	\$88.50 EA	\$442.50
2	606.7815 PLUNGER REV NC	NE	5.00	3/2/2016	\$68.50 EA	\$342.50
3	606.7821 TEST PULL ROD REV NC	NE	5.00	3/2/2016	\$52.50 EA	\$262.50
4	606.7810 PULL ROD HOUSING REV NC	NE	5.00	3/2/2016	\$92.50 EA	\$462.50
5	606.7814 PLUNGER CAP REV NC	NE	5.00	3/2/2016	\$60.50 EA	\$302.50
6	DAS TRANSFER PRICE 15 TRANSFER PRICE		1.00		\$271.88	\$271.88

ALL PARTS TO BE DONE WITH NO
PASSIVATION AND NO
ELECTROPOLISHING. SA 2/17/2016

THIS PO IS FOR RESALE OR
NON-TAXABLE SERVICE.
PLEASE DO NOT ADD SALES&USE TAX
TO ANY ITEM ON THIS PO.

PLEASE CONTACT ME IF THERE ARE
ANY DELAYS OR IF YOU HAVE ANY
QUESTIONS.

Quality Assurance Clauses

Refer to Document # AIPWL7.4.1 QCS Latest Revision for applicable clauses checked below

☒ 1 ☐ 2 ☐ 3 ☐ 4 ☐ 5 ☒ 6 ☐ 7 ☐ 8 ☐ 9 ☐ 10 ☒ 11 ☒ 12
☒ 13 ☒ 14 ☐ 15 ☒ 16 ☐ 17 ☐ 18 ☒ 19 ☒ 20 ☐ 21 ☐ 22 ☐ 23 ☐ 24
☐ 25 ☐ 26 ☐ 27 ☐ 28 ☒ 29 ☐ 30 ☐ 31 ☐ 32 ☐ 33 ☐ 34 ☒ 35 ☐ 36
☐ 37 ☐ 38 ☐ 39 ☐ 40

Item Total: \$1,812.50

Authorized Signatures: See Below

See last page for totals

Purchasing:

QC:

Production:



Apical Industries, Inc.
dba Dart Aerospace
3030 Enterprise Ct., Suite A
Vista, CA 92081-8347
T 760 724 8300
F 760 509 1562

Change Order

Order #: P1559
Prepared By: Sarah Arango
Date Printed: 2/17/2016
Time: 11:02:02 AM
of Items: 6
Page: 2

Purchased From:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Ship To:
Apical Industries, Inc.
dba DART Aerospace
3030 Enterprise Court
Suite A
Vista, CA 92081
United States

PO Date: 2/16/2016 Cust Ref#: E-MAIL REQ JACO Vendor #: DAL1 Customer:
Need Date: 0 Terms: NET 30 DAY Phone #: 1-613-632-3336 Fax #: 1-613-632-4443
Remarks: E-MAIL REQ JACOB. B CABLE KITS Resale: YES Resale #:

Insure?: Please Insure Ship Via: UPS GROUND

Account:

FOB: ON

Change Order -- Do Not Duplicate

Item	Part Number/Description	CD	Qty	Req Date	Unit Price	Line Amt
	ALWAYS INCLUDE PACKING SLIP WITH SHIPMENT. Sarah Arango Dart Aerospace Phone: 760-509-1608 Fax: 760-758-9612 sarango@dartaerospace.com					

Quality Assurance Clauses

Refer to Document # AIPWL-7.4.1 QCS Latest Revision for applicable clauses checked below

☐ 1 ☐ 2 ☐ 3 ☐ 4 ☐ 5 ☐ 6 ☐ 7 ☐ 8 ☐ 9 ☐ 10 ☐ 11 ☐ 12
☐ 13 ☐ 14 ☐ 15 ☐ 16 ☐ 17 ☐ 18 ☐ 19 ☐ 20 ☐ 21 ☐ 22 ☐ 23 ☐ 24
☐ 25 ☐ 26 ☐ 27 ☐ 28 ☐ 29 ☐ 30 ☐ 31 ☐ 32 ☐ 33 ☐ 34 ☐ 35 ☐ 36
☐ 37 ☐ 38 ☐ 39 ☐ 40

Item Total: \$1,812.50

Charges: \$271.88

Total: \$2,084.38

US Dollars

Authorized Signatures: See Below

dba3030R3

Purchasing:

QC:

Production: